

Work Order ID 113991

Friday, February 28, 2014 10:04:58 AM

113991

Page 1

Item ID: D4467-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: mf

Date: 14-2-28 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4467	D
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100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

14/4/20 (1)

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and install rivet wet using proseal (see note 8)

Seal gaps with proseal as per dwg (see note 9)

Coat both faces of D4469-1 skin locally using proseal prior to installation of D4759-1 scuff strip. (see note 10)

Proseal 890 B-2 Batch 1130986

DAS
36
9-89

15/01/12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>113 991</u> Part No. <u>D4469-092</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐	15/01/12	110		2 D4469-1 were scrap because Template was not good led to modified 2 Times 1 was scrap because when body was assembly hole didn't match had to do one when the assembly was done <i>1st & 2nd</i>	<i>15/01/12</i> <i>AS</i>	made sig for the location of the D4469-1 & new Tooling	DAS 30 9-89 15/01/12	RB 15-04-06	DAS 9 9-89 15-04-06
Doc/Data ☐									
Equip/Tooling ☒									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

1st & 2nd Time door was made

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 113991

Friday, February 28, 2014 10:04:58 AM

113991

Page 2

Item ID: D4467-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 0.00 JAN 24 2015 15-01-12
120 QC Quality Control	Memo	0.00							
130	Identify as per dwg & Stock Location GA	0.00			DAS 30 0.00	1			15/02/10
130 Packaging Packaging	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	Memo	0.00							mt 10-3-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.03 per dwg revC DD VERF:JLM IPP
REV:B 13.02.11 PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4469-1		Manufactured	No				Each	0.0000					
D4469-1													
Outer Skin Lower Door													
D4470-042		Manufactured	No				Each	1.0000		1			
D4470-042													
Aft Rib Assembly, RH													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	1							
					96011	1							
D4471-042		Manufactured	No				Each	2.0000		1			
D4471-042													
Mid Rib Assembly, RH													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	2							
					96299	2							
D4472-042		Manufactured	No				Each	0.0000		1			
D4472-042													
Fwd Rib Assembly, RH													
D4473-042		Manufactured	No				Each	1.0000					
D4473-042													
Small Rib Assembly, RH													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	1							
					96013	1							

****** 125866
~~11020~~ MF 14-4-28

****** 119206
MF 14-4-28

****** MF 14-4-28

****** 1130998
11942 MF 14-4-28

****** 123280
MF 14-4-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design ☐											
Doc/Data ☐											
Equip/Tooling ☐											
Handling/Pre ☐											
Material ☐											
Operator ☐											
Offset/Setup ☐											
Process ☐											
Supplier ☐											
Training ☐											
Transport ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function			☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence			☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

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Page 2

Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

D4474-1 Manufactured No

Each 6.0000 1

D4474-1

Splice Block

Location

Loc Qty

Loc Code

CA
95477

6
6

Each 9.0000

MF 14-4-28
1

D4475-041 Manufactured No

D4475-041

Small Rib Assembly

Location

Loc Qty

Loc Code

CA
84575
98527

9
3
6

Each 1.0000

DAS
32
9-89

98527
1

D4476-042 Manufactured No

D4476-042

Small Rib Assembly, RH

Location

Loc Qty

Loc Code

CA
96014

1
1

Each 10.0000

123279
MF 14-4-28
1

D4477-041 Manufactured No

D4477-041

Small Rib Assembly

Location

Loc Qty

Loc Code

CA
95478
98528

10
4
6

Each 0.0000

MF 14-4-8
1

D4478-042 Manufactured No

D4478-042

Intercostal 1 Assembly, RH

113997 MF 14-7-31

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

D4479-042

Manufactured No

Each

1.0000

1

DAS
32
9-89

D4479-042

Intercoastal 2 Assembly, RH

Location

Loc Qty

Loc Code

ST109

1

99124

1

Each

0.0000

1

DAS
32
9-89

D4481-042

Manufactured No

D4481-042

Intercoastal 4 Assembly, RH

D4482-042

Manufactured No

Each

0.0000

1

D4482-042

Intercoastal 5 Assembly, RH

D4483-042

Manufactured No

Each

0.0000

1

D4483-042

Fwd Closeout Panel Assembly, RH

D4484-042

Manufactured No

Each

0.0000

1

D4484-042

Bottom Panel Assembly, RH

D4484-044

Manufactured No

Each

0.0000

1

DAS
32
9-89

D4484-044

Aft Bottom Panel Assembly, RH

D4485-1

Manufactured No

Each

5.0000

1

D4485-1

Lower Closeout Panel

Location

Loc Qty

Loc Code

CA

5

95489

5

Each

0.0000

1

D4486-4

Manufactured No

D4486-4

Fwd Access Panel, RH

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 4

Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

D4486-042

Manufactured No

Each

1.0000

1

DAS
32
9-89

D4486-042

Access Panel Assembly, RH

**

Location

Loc Qty

Loc Code

ST109

1

99102

1

Each

1.0000

1

Handwritten: B123228 14923

D4487-042

Manufactured No

D4487-042

Closeout Panel Assembly, RH

**

Location

Loc Qty

Loc Code

ST109

1

99105

1

Each

3.0000

1

DAS
32
9-89

D4488-5

Manufactured No

D4488-5

Angle Clip

**

Location

Loc Qty

Loc Code

CA

3

84446

3

Each

5.0000

1

DAS
32
9-89

D4490-1

Manufactured No

D4490-1

Splice Plate

**

Location

Loc Qty

Loc Code

CA

5

95492

5

Each

6.0000

1

DAS
32
9-89

D4490-3

Manufactured No

D4490-3

Splice Plate

**

Location

Loc Qty

Loc Code

CA

6

95493

6

Handwritten: 95493

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY							
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube		General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function		☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

D4494-042

Manufactured No

Each

1.0000

1

D4494-042

Upper Block Assembly, RH

Location

Loc Qty

Loc Code

CA

1

1

Each

4.0000

1

D4521-1

Manufactured No

D4521-1

Doubler Lower Door

Location

Loc Qty

Loc Code

CA

4

4

Each

9.0000

1

D4570-5

Manufactured No

D4570-5

Bracket

Location

Loc Qty

Loc Code

CA

9

3

6

Each

0.0000

1

D4759-1

Manufactured No

D4759-1

Scuff Strip

MS20426AD3

Purchased No

Each

1,868.000

54

MS20426AD3-3

RIVET

Location

Loc Qty

Loc Code

ST334

1868

123352

1868

MF 14-5-5.
123278

MF 14-4-28

DAS
32
9-89

86401

99178 MF 14-5-01

54 M 125445

1428754 DAS
32 14/4/28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4

Purchased

No

Each

9,927.000

18

MS20426AD3-4

**

DAS
32
9-89

RIVET

Location

Loc Qty

Loc Code

MF4

561

125578

561

ST334

4000

m127432

4000

ST509

5366

125578

5366

m125388

DAS
32
9-89

MS20426AD4-4

Purchased

No

Each

3,322.000

3

MS20426AD4-4

**

Rivet

Location

Loc Qty

Loc Code

GA

339

129090

339

ST334

2983

125445

2983

126440

38

DAS
32
9-89

MS20426AD4-6

Purchased

No

Each

2,847.000

MS20426AD4-6

**

Rivet

Location

Loc Qty

Loc Code

GA

1501

m126474

1501

MF4

142

124392

142

ST334

1204

124392

1204

124392

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-8

Purchased

No

Each

1,476.000

4

MS20426AD4-8

**

RIVET

Location

Loc Qty

Loc Code

Mezz

1476

18136

1476

Each

5,399.000

71

MS20470AD4-3

Purchased

No

MS20470AD4-3

**

Rivet - Universal Head

Location

Loc Qty

Loc Code

GA

1516

1642

73

2193

1443

ST335

3883

2193

3883

Each

236.0000

20

MS20470AD4-4

Purchased

No

MS20470AD4-4

**

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

180

121652

180

ST336

56

118614

56

Each

1,340.000

22

MS20470AD4-5

Purchased

No

MS20470AD4-5

**

RIVET, UNIVERSAL HEAD

Location

Loc Qty

Loc Code

GA

335

m126926

335

ST336

1005

m126926

1005

DAS
32
9-89

1130 224

71

2193

DAS
32
9-89

118614

DAS
32
9-89

17/4/28

m126926

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-6

Purchased

No

Each

1,587.000

1

MS20470AD4-6

RIVET

**

DAS
32
9-89

Location

Loc Qty

Loc Code

GA

762

118927

762

ST336

825

m127831

825

m127831

Each

1,180.000

27

MS20601-AD4W3

Purchased

No

MS20601-AD4W3

Rivet

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST311

600

124331

600

ST506

80

124365

80

st533

500

114538

500

54 m124331

MS20615-3M3

Purchased

No

MS20615-3M3

RIVET

**

DAS
32
9-89 1/4/7/28

Location

Loc Qty

Loc Code

ST312

1494

124859

1494

124859

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

Each

352.0000

2

MS21043-3

Nut

**

M 128 398 ^{DAS}
32
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

272

124555

59

m126741

213

MS21059L3K

Purchased

No

Each

879.0000

9

MS21059L 3K

Nutplate

**

^{DAS}
32
9-89

Location

Loc Qty

Loc Code

GA

257

m127635

257

ST316

622

m127703

622

MS21069L08

Purchased

No

Each

1,876.000

1

MS21069L 08

ANCHOR NUT

**

^{DAS}
32
9-89

Location

Loc Qty

Loc Code

ST317

1876

123522

1876

MS24694-S4

Purchased

No

Each

180.0000

11

MS24694-S4

Screw

**

^{DAS} 14/4/25
32
9-89

Location

Loc Qty

Loc Code

ST302

180

11788

80

123292

100

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS24694-S5

Purchased

No

Each

392.0000

7

DAS
32
9-89

MS24694-S5

Screw

Location

Loc Qty

Loc Code

ST302

392

18949

51

19073

341

18949

MS24694-S56

Purchased

No

Each

85.0000

4

DAS
32
9-89

MS24694-S56

SCREW

Location

Loc Qty

Loc Code

ST303

85

m126400

85

m126400

MS27039-1-14

Purchased

No

Each

1,027.000

2

DAS
32
9-89

MS27039-1-14

Screw

Location

Loc Qty

Loc Code

GA

98

120449

98

ST506

264

124326

264

st507

665

124326

665

m124326

MS27039-08-07

Purchased

No

Each

189.0000

2

DAS
32
9-89

MS27039-08-07

SCREW

m128402

14/4/21

Location

Loc Qty

Loc Code

ST307

189

122563

12

m128300

177

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Work Order ID: 113991

113991

Parent Item: D4467-042

D4467-042

Parent Item Name: Lower Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

Each

2,332.000

2

DAS

NAS1149DN832.J

**

32

Washer

9-89

Location

Loc Qty

Loc Code

MF4

1000

M127255

1000

ST293

1000

M127813

1000

st510

315

124555

315

ST510a

17

M126319

17

NAS1149D0332J

Purchased

No

Each

950.0000

4

NAS1149D0332.J

**

Washer

Location

Loc Qty

Loc Code

GA

179

m127916

179

ST293

416

m127389

31

m127431

385

ST294

5

m125807

5

ST510a

350

m127916

350

DAS

32

9-89

14/7/25 (1)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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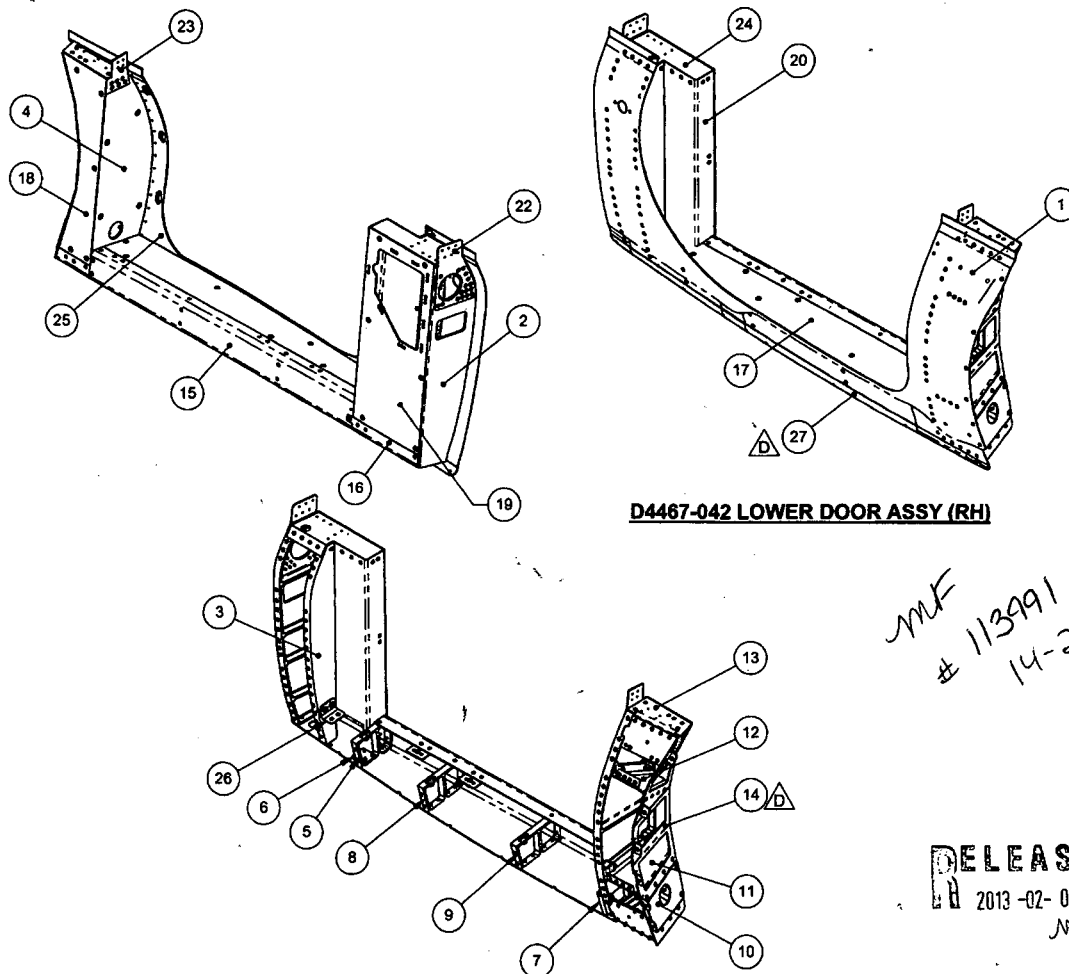
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4467-042	LOWER DOOR ASSY (RH)
1	1	D4469-1	OUTER SKIN LOWER DOOR
2	1	D4470-042	AFT RIB ASSY (RH)
3	1	D4471-042	MID RIB ASSY (RH)
4	1	D4472-042	FWD RIB ASSY (RH)
5	1	D4473-042	SMALL RIB ASSY (RH)
6	1	D4474-1	SPLICE BLOCK
7	1	D4475-041	SMALL RIB ASSY
8	1	D4476-042	SMALL RIB ASSY (RH)
9	1	D4477-041	SMALL RIB ASSY
10	1	D4478-042	INTERCOSTAL 1 ASSY (RH)
11	1	D4479-042	INTERCOSTAL 2 ASSY (RH)
12	1	D4481-042	INTERCOSTAL 4 ASSY (RH)
13	1	D4482-042	INTERCOSTAL 5 ASSY (RH)
14	1	D4483-042	FWD CLOSEOUT PANEL ASSY (RH)
15	1	D4484-042	BOTTOM PANEL ASSY (RH)
16	1	D4484-044	AFT BOTTOM PANEL ASSY (RH)
17	1	D4485-1	LOWER CLOSEOUT PANEL
18	1	D4486-4	FWD ACCESS PANEL (RH)
19	1	D4486-042	ACCESS PANEL ASSY (RH)
20	1	D4487-042	CLOSEOUT PANEL ASSY (RH)
21	1	D4488-5	ANGLE CLIP
22	1	D4490-1	SPLICE PLATE
23	1	D4490-3	SPLICE PLATE
24	1	D4494-042	UPPER BLOCK ASSEMBLY (RH)
25	1	D4521-1	DOUBLER (LOWER DOOR)
26	1	D4570-5	BRACKET
27	1	D4759-1	SCUFF STRIP
28	54	MS20426AD3-3	RIVET, CSK
29	18	MS20426AD3-4	RIVET, CSK
30	3	MS20426AD4-4	RIVET, CSK
31	38	MS20426AD4-6	RIVET, CSK
32	4	MS20426AD4-8	RIVET, CSK
33	71	MS20470AD4-3	RIVET, PAN HEAD
34	20	MS20470AD4-4	RIVET, PAN HEAD
35	22	MS20470AD4-5	RIVET, PAN HEAD
36	1	MS20470AD4-6	RIVET, PAN HEAD
37	27	MS20601AD4W3	RIVET, CSK BLIND
38	6	MS20615-3M3	RIVET
39	2	MS21043-3	NUT
40	9	MS21059-3K	NUTPLATE
41	1	MS21069L08	NUTPLATE
42	11	MS24694-S4	SCREW
43	7	MS24694-S5	SCREW
44	4	MS24694-S56	SCREW
45	2	MS27039-1-14	SCREW
46	2	MS27039-0807	SCREW
47	2	NAS1149DN832J	WASHER
48	4	NAS1149D0332J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.65 lbs
- 8) INSTALL ALL RIVETS WET USING PROSEAL 890 B-2 (PRC)
- 9) SEAL ALL GAPS ON MATING PARTS USING PROSEAL 890 B-2 (PRC)
- 10) COAT BOTH FACES OF THE D4469-1 SKIN LOCALLY USING PROSEAL 890 B-2 (PRC) PRIOR TO INSTALLATION OF D4759-1 SCUFF STRIP.



D4467-042 LOWER DOOR ASSY (RH)

mf
113991
14-2-28

RELEASED
2013-02-08

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	AS	D4467	SHEET 6 OF 10
APPROVED	AS	TITLE	SCALE
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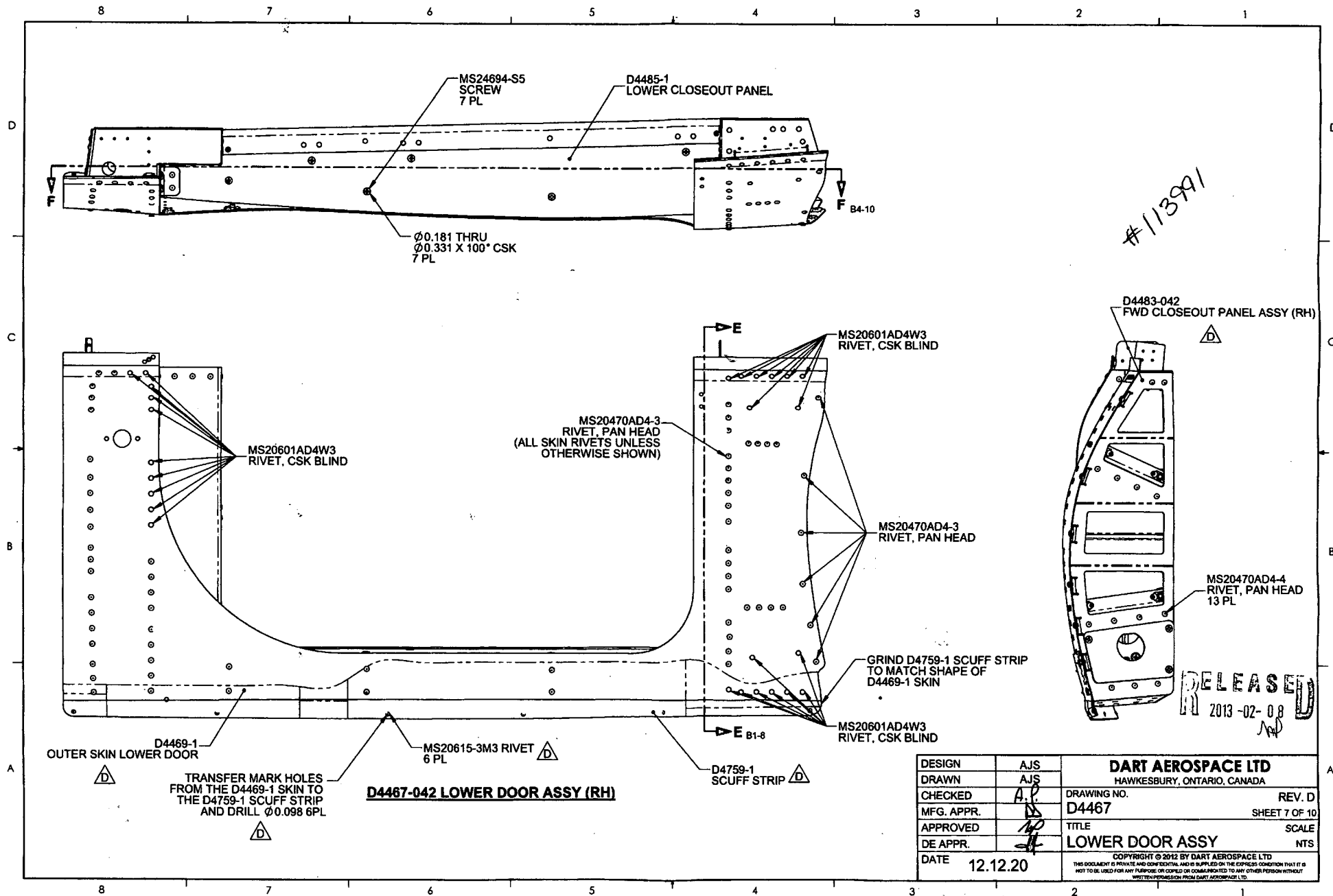
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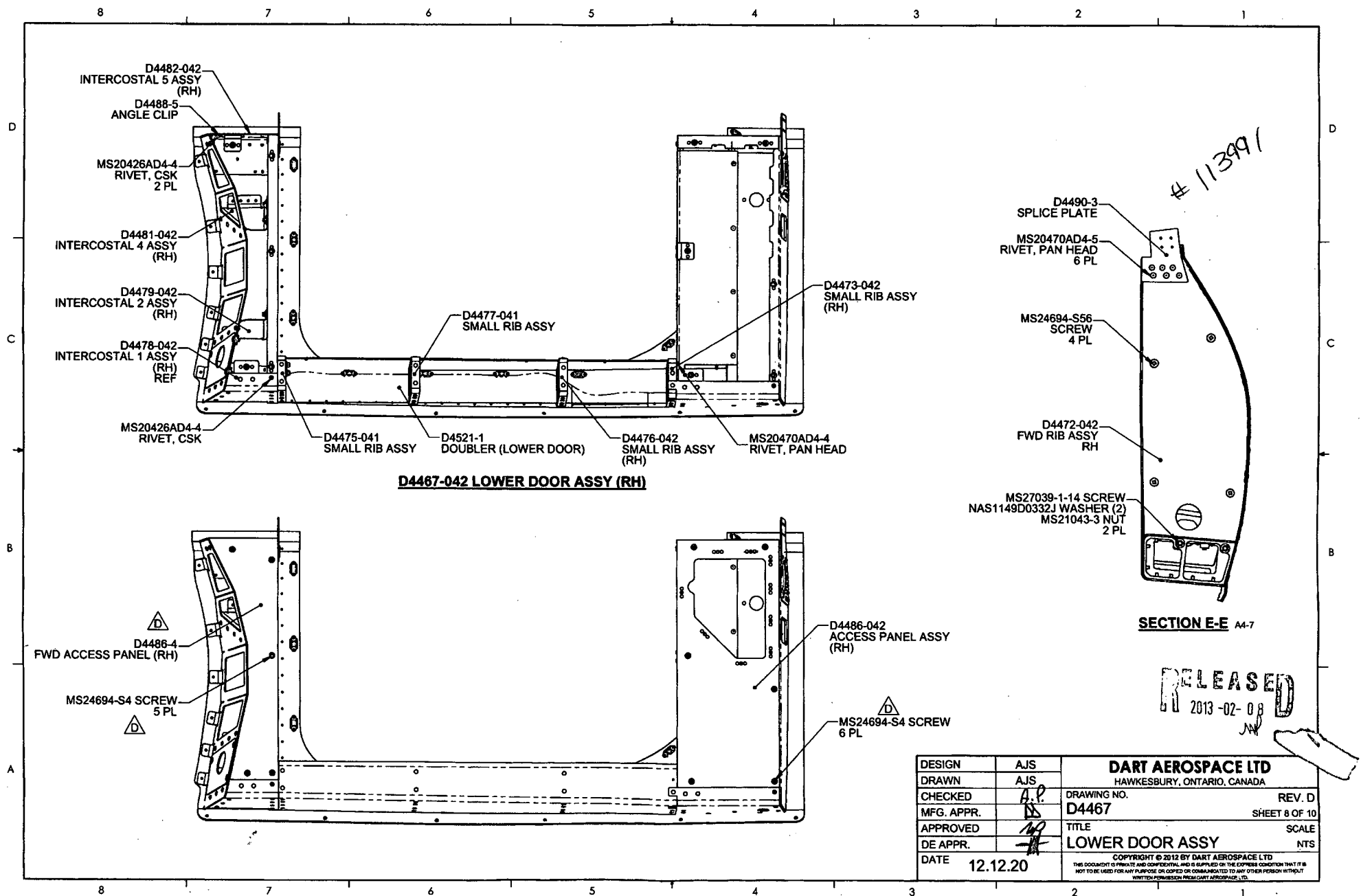
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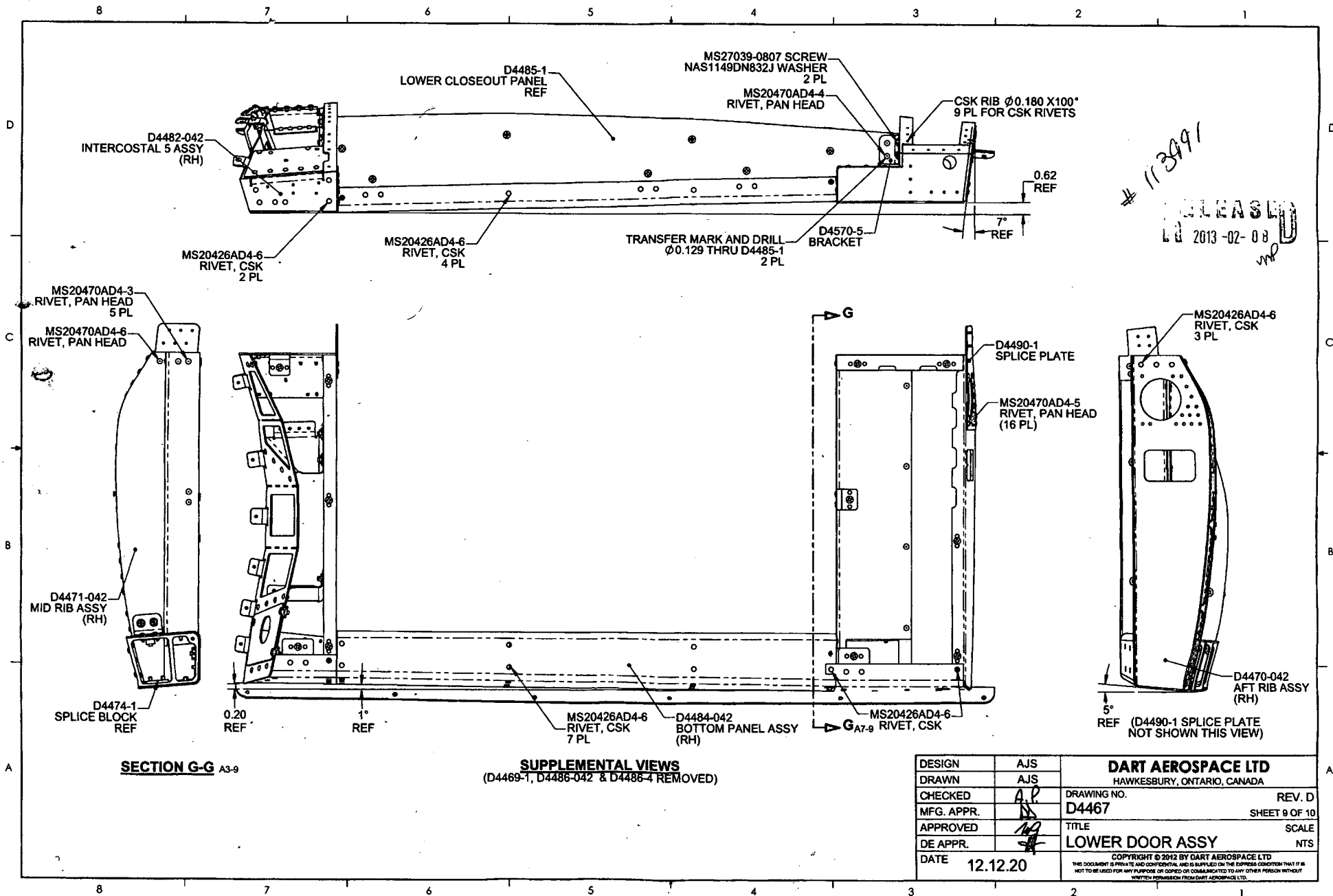
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